

Date: Monday, 2/19/2007 3:27:04 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TAIL LIGHT FAIRING
Job Number : 30772	
Estimate Number : 12360	
P.O. Number : <i>N/A</i>	Part Number : D34843
This Issue : 2/19/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3484 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 27223	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 3/10/2007 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.02.19	
Comment : Est Rev: A New Issue 06-04-11 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.0565 sf(s)/Unit Total : 0.2825 sf(s)

6061-T6 .050 Sheet

(M6061T6S050)

Batch: *117347**SAD 07/02/24**5*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3484

*SAD 07/02/24**6*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/02/24**5*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SG 07.02.25**5*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr *SAD 07/02/25* *(5)*

2-C'sink as per Dwg D3484

*m 07/03/05 x5*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PP Date: 07/04/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 3:27:04 PM  
User: Kim Johnston

## Process Sheet

✓ Customer: CU-DAR001 Dart Helicopters Services Drawing Name: TAIL LIGHT FAIRING  
Job Number: 30772 Part Number: D34843

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

207/03/20 (5)

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

207/04/10 (5)

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FD 07/10/11 (5)

Job Completion



U 07/04/11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

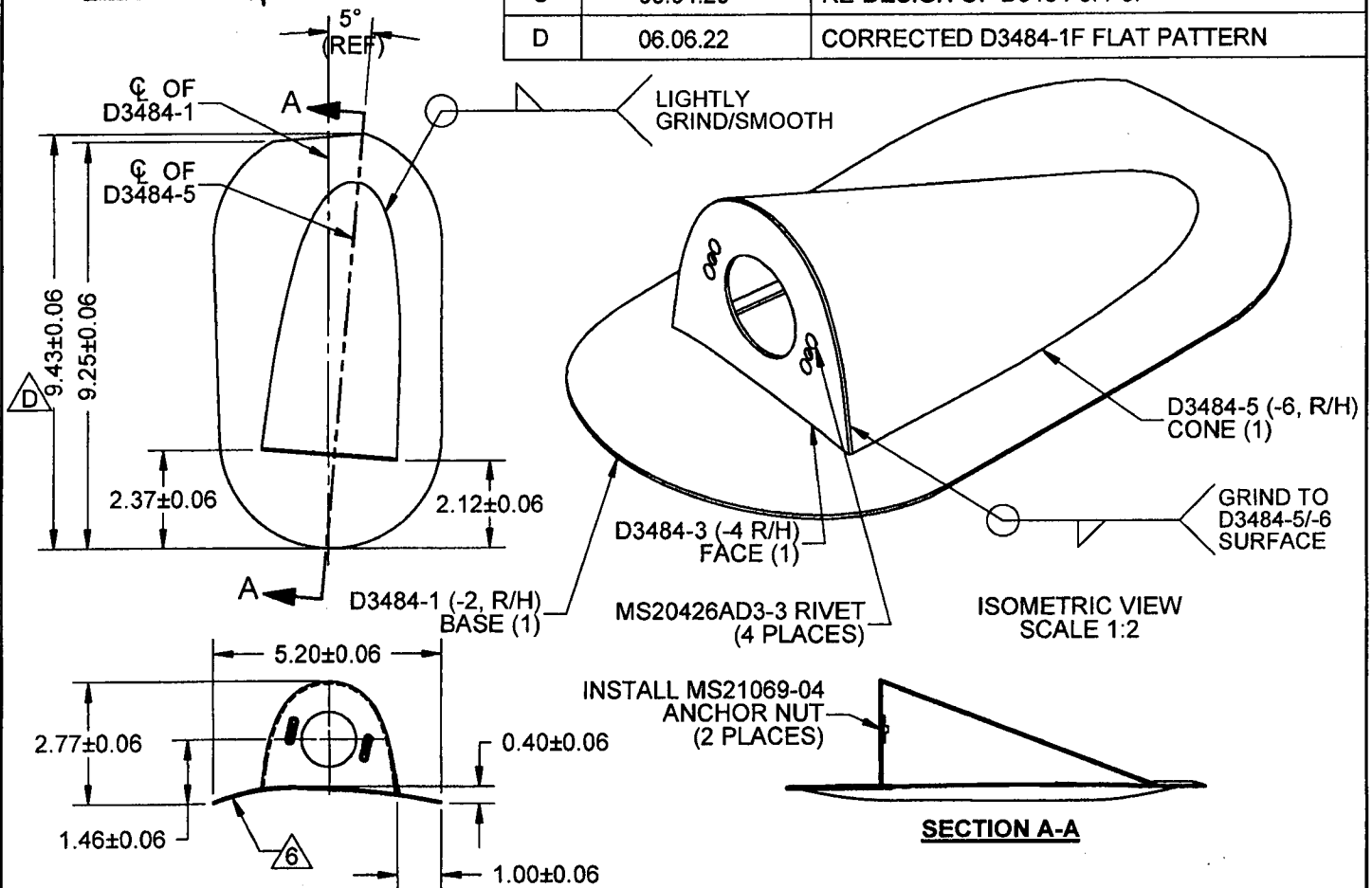
**NOTE:** Date & initial all entries

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3484</b>	REV. D SHEET 1 OF 4
DATE		TITLE <b>TAIL LIGHT FAIRING</b>	SCALE 1:4
	06.06.22		
A	05.11.29	NEW ISSUE	
B	06.02.21	RE-DESIGN	
C	06.04.20	RE-DESIGN OF D3484-3F/-5F	
D	06.06.22	CORRECTED D3484-1F FLAT PATTERN	

RELEASED

06.08.17

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD.,  
P/N D412-750-141/-142 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE  
PDA06-13"

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (L/H)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (R/H)
1		D3484-1	BASE (L/H)
	1	D3484-2	BASE (R/H)
1		D3484-3	FACE (L/H)
	1	D3484-4	FACE (R/H)
1		D3484-5	CONE (L/H)
	1	D3484-6	CONE (R/H)
4	4	MS20426AD3-3	RIVET
2	2	MS21069-04	ANCHOR NUT

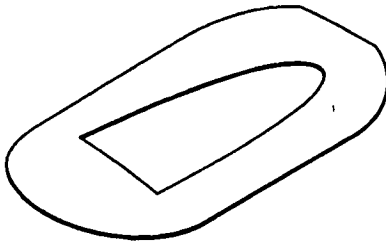
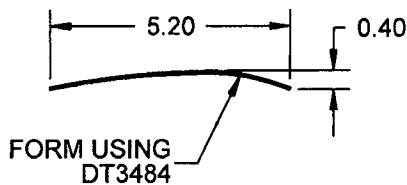
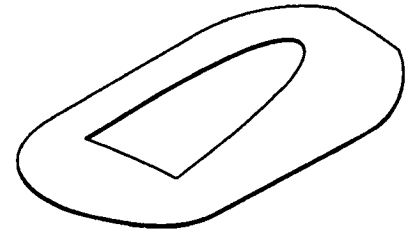
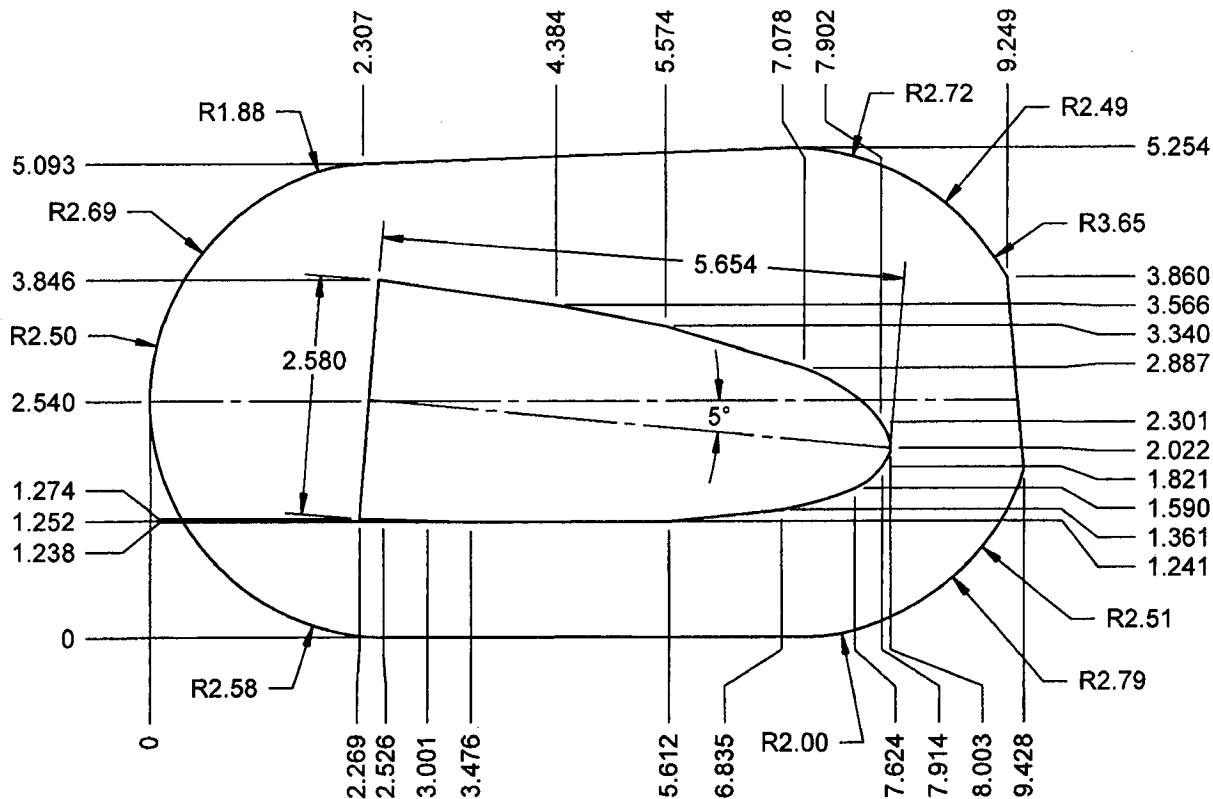
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3484</b>	REV. D SHEET 2 OF 4
DATE <b>06.06.22</b>	TITLE <b>TAIL LIGHT FAIRING</b>		SCALE 1:2

**D3484-1 BASE, L/H****D3484-1 BENDING DETAIL**  
(D3484-2 OPPOSITE)  
(MAKE FROM D3484-1F)**D3484-2 BASE, R/H****D3484-1F BASE FLAT PATTERN** **NOTES:**

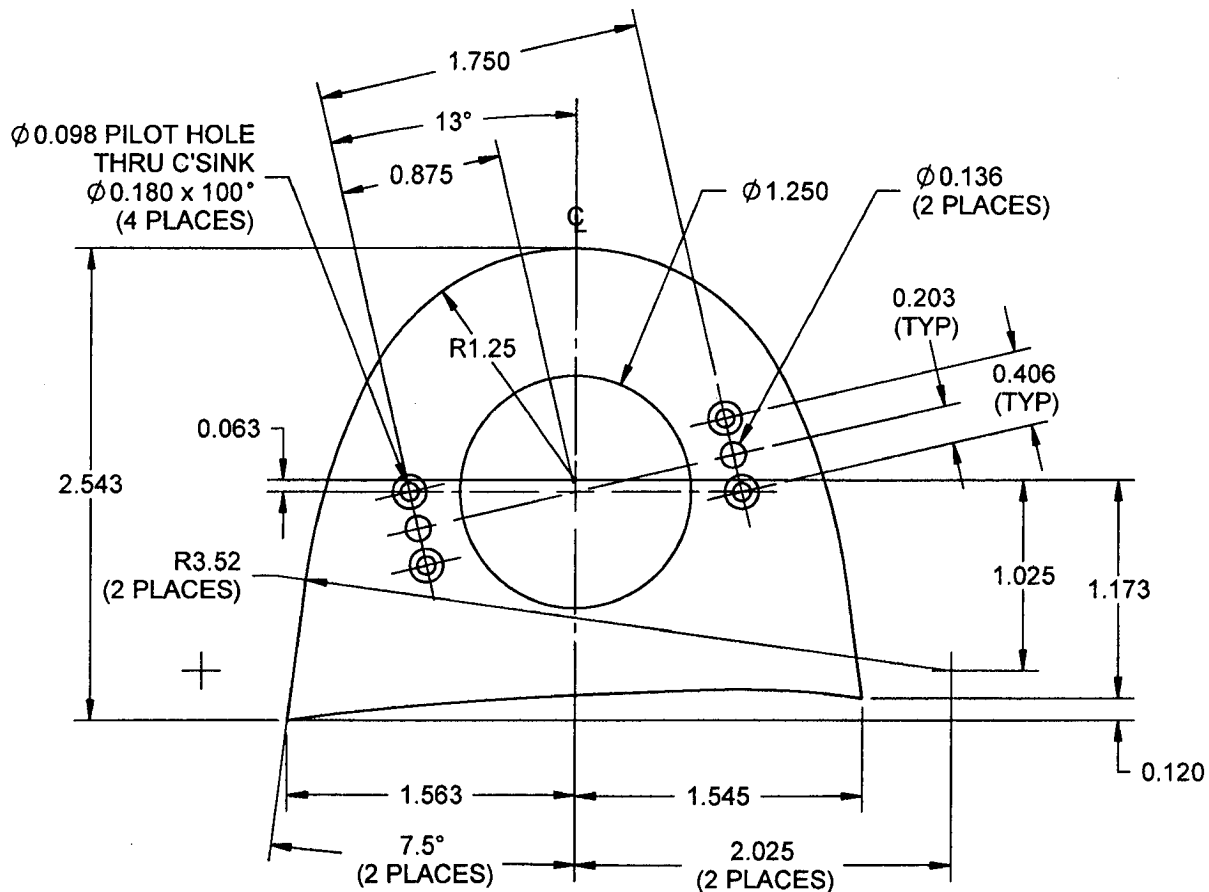
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 06.06.22		TITLE TAIL LIGHT FAIRING	SCALE 1:1

**RELEASED**06.08.17 *[Signature]***D3484-3 L/H FACE (-4 R/H, OPPOSITE)****NOTES:**

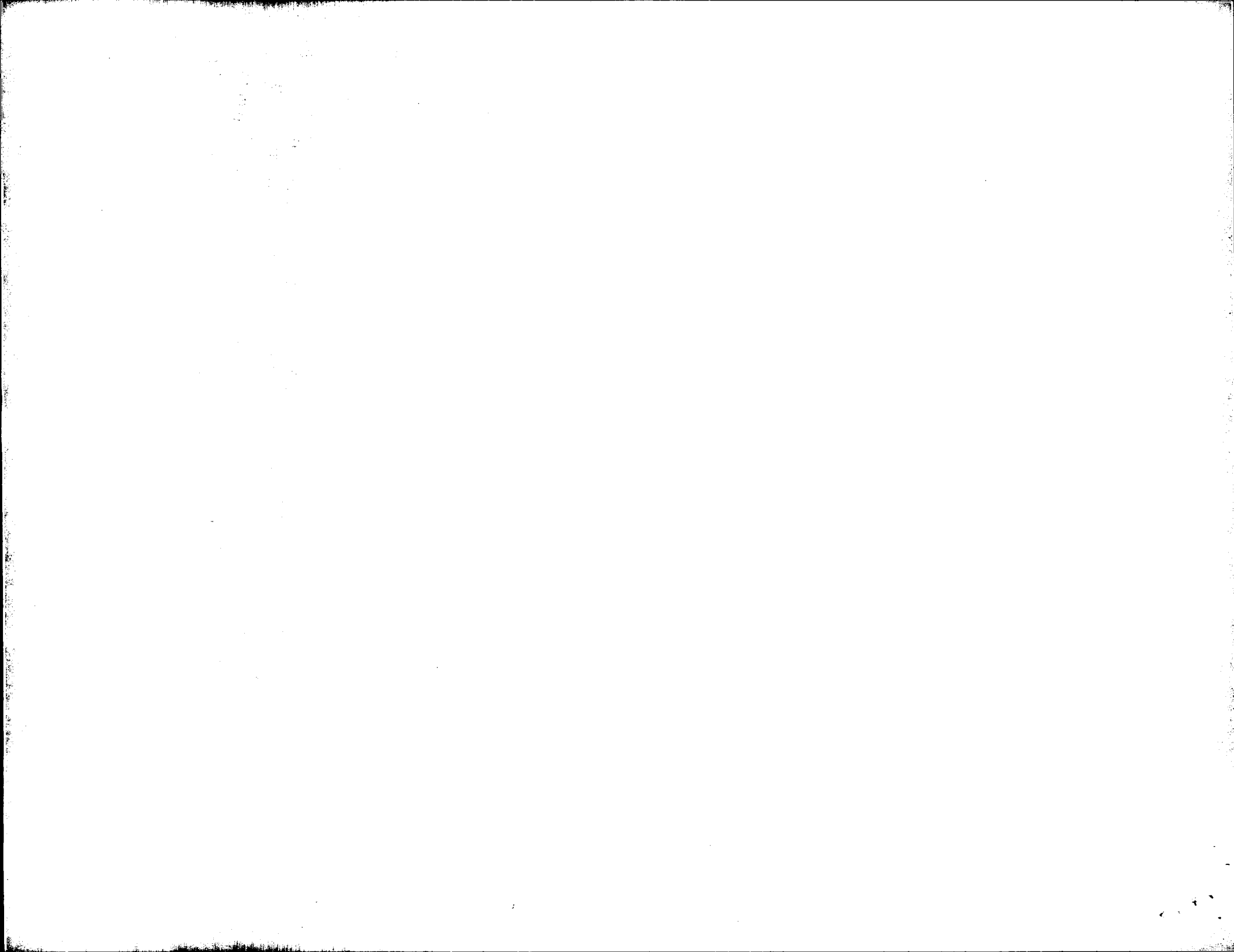
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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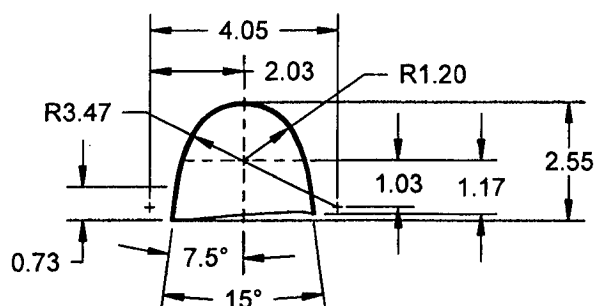
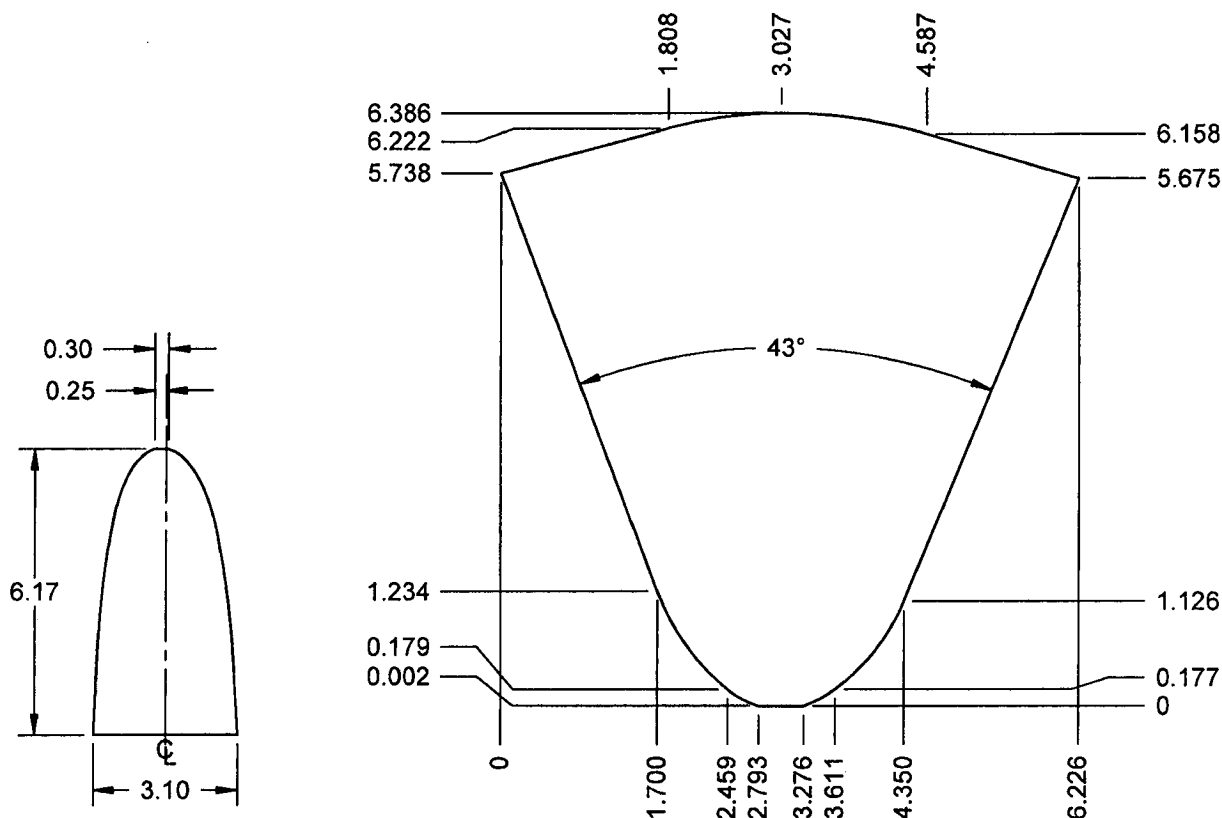
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DATE <b>06.06.22</b>		TITLE <b>TAIL LIGHT FAIRING</b>	SCALE 1:4



**D3484-5F CONE FLAT PATTERN**

RELEASED  
06.08.17 *[Signature]*

**D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)**  
(MAKE FROM D3484-5F)

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype
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[illegible]

Measured by:	JAN	Audited by:	[Signature]	Prototype Approval:	[Signature]
Date:	07/02/24	Date:	07-02-24	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	